

Date: Wednesday, 3/8/2006 10:40:39 AM
 User: Kim Johnston

Process Sheet

Split
 80 06/05/16 15

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26136
 Estimate Number : 12027
 P.O. Number : N/A
 This Issue : 3/8/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 25908
 Written By : *See comment below*
 Checked & Approved By : *06.03.08 W*
 Comment : Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J LM

Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
 Part Number : D412630024
 Drawing Number : D412-630 REV. J, P13
 Project Number : N/A
 Drawing Revision : J
 Material : N/A
 Due Date : 4/15/2006
 Qty: *24 x 5* Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-024 CHG002

D412-630-024

2.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

B25 483

3.0

D2803042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

B25 918

4.0

D2804042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

B25 920-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

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NOTE: Date & initial all entries

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Part Number: D412630024

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2807 Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

26646
~~B2597~~

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

B26649

7.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

~~B26584~~ B25935

8.0 D3388042 Step Weldment RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Step Weldment RH

26653

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

M19633 M18515

10.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description

Batch

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Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #: Machine Or Operation: Description :

2 AN310C8 Nut

M18515

11.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M18779

12.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M100218

13.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

14.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M16984

15.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

W/O:		WORK ORDER CHANGES					
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Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M100050

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M100446 (2)
M18779 (10) JAD 06-05-16 (2)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.13

JAD 06-06-12 (2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JAD 06-06-12 (2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

B25921 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~2.0000~~ Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-3

Description

Bushing

Batch

B26160 x 2

B25922 x 7 -
B25869 x 1 ✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

Strut

Pick: Packing Kit

Qty Part Number

1 D2810-5

Description

Strut

Batch

B26758 x 1 ✓

B26758 x 2 ✓
B266407

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~2.0000~~ Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

2 D3396-1

Description

Spacer

Batch

B24645 ✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

1 AN4C6A

Description

Bolt

Batch

M19512 ✓

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

1 AN4C10A

Description

Bolt

Batch

M18515 ✓

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Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

719600 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

719620 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

718167 ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

7100651 ✓

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

718535 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H4

Description

Washer

Batch

M100680 ✓

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H5

Description

Washer

Batch

M19565 ✓

AB 06/05/19

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/5/23 (2) 06/6/13 (3)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location:

PPP Rev: A

06/5/23 (2) 06/6/13 (3)

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/13 (3)


Job Completion



u 06/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

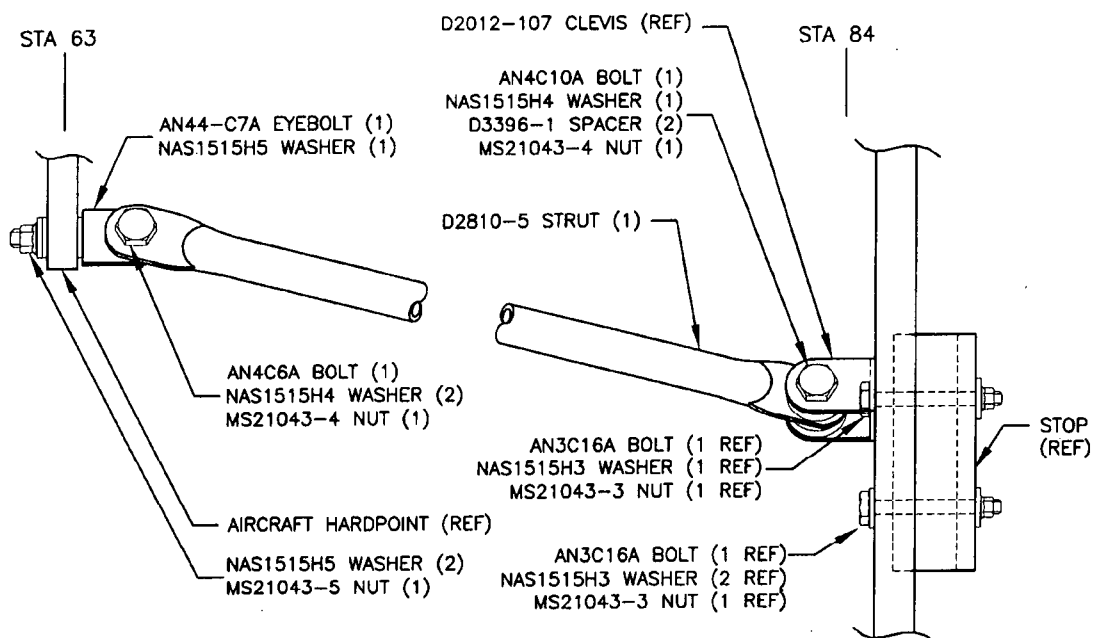
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒  Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step*™ Installation
(NOT TO SCALE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26136

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Revision: J
Date: 05.12.08